Date:

Friday, 21/07/2006 12:04:08 PM

User:

Linda Lacelle

### **Process Sheet**

Customer **Job Number Estimate Number** 

: CU-DAR001 Dart Helicopters Services

: 10994

P.O. Number This Issue

Prsht Rev.

First Issue

:NIA

: 21/07/2006

: NC : MA

Type

: MACHINED PARTS

S.O. No. : NA

: 28018 **Previous Run** Written By

**Checked & Approved By** 

Comment

: Est: processDM

D 06.07.21

Waterjet EC

Removed P/O for Powder Coat- in house

**Part Number Drawing Number** 

**Drawing Name** 

: D2583

: D2583 REV. B : N/A

: LATCH BRACKET

Project Number **Drawing Revision** 

:NA Material **Due Date** 

: 12/08/2006

Qty:

100 Um:

Each

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Est:

Description:

1.0 M5052H32S040



Comment: Qty.:

0.1227 sf(s)/Unit Total:

12.2745 sf(s)

Material: 5052-H32 (QQ-A-250/8) 0.040" thick

(M5052H32S040)

Batch: M17835 158

5052-H32 .040 Sheet

M15982 (52)

2.0

WATER JET



**Comment: FLOW WATER JET** 

1-Cut as per Dwg D2583 Dwg Rev: 13 

2-Deburr if necessary -

Loulos/18 (10) - MF. 06/08/32 (110)

11 D

3.0

QC2





Comment: INSPECT PARTS AS THEY COME OFF MACHINE

110

4.0

QC8

SECOND CHECK

**Comment: SECOND CHECK** 

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr

Form on CNC Brake as per-Dwg D2583



Date: Friday, 21/07/2006 12:04:09 PM User: Linda Lacelle **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services **Drawing Name: LATCH BRACKET** Job Number: 28018 Part Number: D2583 Job Number: Seq. #: Description: **Machine Or Operation:** HAND FINISHING1 HAND FINISHING RESOURCE #1 6.0 Comment: HAND FINISHING RESOURCE #1 SAD Acid etch and Alodine as per QSI 005 4.1 110 POWDER COATING 7.0 POWDER COATING **Comment: POWDER COATING** 06 Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSION 8.0 QC3 POWDER COAT/CHEMICAL CONVERSION 9.0 PACKAGING 1 PACKAGING RESOURCE #4 **Comment: PACKAGING RESOURCE #1** Identify and Stock Location: 10.0 DC DOCUMENT CONTROL

Comment: DOCUMENT CONTROL Inspection Level 21

Job Completion



1 2/ 19.1

PTO

Date:

Friday, 7/21/2006 7:37:24 AM

User:

Kim Johnston

### **Process Sheet**

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number** 

: 28018 : 10994

P.O. Number

: 7/21/2006 This Issue

: NC

: // : 25326 Type

S.O. No. :

: MACHINED PARTS

**Part Number** 

**Drawing Name** 

: D2583

**Drawing Number** 

: D2583 REV. B

: LATCH BRACKET

Project Number **Drawing Revision**  : N/A : B

Material

**Due Date** 

: 8/12/2006

Qty:

100 Um:

Each

Written By

Prsht Rev.

First Issue

**Previous Run** 

**Checked & Approved By** Comment

: Est:

Removed P/O for Powder Coat- in house

processDM

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

M5052H32S040 1.0

5052-H32 .040 Sheet



Comment: Qty.:

0.1227 sf(s)/Unit Total:

12.2745 sf(s) Material: 5052-H32 (QQ-A-250/8) 0.040" thick

(M5052H32S040)

Batch:

2.0

SHEAR



Comment: SHEAR

Cut blank: 4.000" x 2.130" Grain offset 10° along 3.188"

3.0

HAAS1

SHEAR

HAAS CNC VERTICAL MACHINING #1





Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio D2583

4.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

BRAKE NO

NC BRAKE



Comment: NC BRAKE

Deburr

Form on CNC Brake as per Dwg D2583

# **Dart Aerospace Ltd**

W/O:	, , , , , ,	WORK ORDER CHANGES					,
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06-06-28	5.0	ADD QCS to inspect bending. Perm. Change	k	06.68.29		Dogwy	
	5-1	QC 5 Inspect work.	1	ch.ug.28	110	1	66.08.28

NCR:			WORK ORDE	ER NON-CONFORMANC	E (NCR)			
		Description of NC	Corrective Action Section B			Verification	Ammayal	
DATE	DATE STEP	Section A	Initial Design Mgr	Action Description  Design Mgr	Sign & Date	Section C	Approval Design Mgr	Approval QC Inspector
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<u>.</u>								

Part No:	PAR #:	Fault Category:	NCR:	Yes No DQA:	D.	ate: <u>26/05/11</u>
NOTE: Date & initial all entries				QA: N/C Closed:	D	ate:

Date: Friday, 7/21/2006 7:37:24 AM User: Kim Johnston **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: LATCH BRACKET Job Number: 28018 Part Number: D2583 Job Number: Seq. #: **Machine Or Operation:** Description: HAND FINISHING RESOURCE #1 HAND FINISHING1 6.0 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 7.0 POWDER COATING Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 8.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 9.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 10.0 DC DOCUMENT CONTROL Comment: DOCUMENT CONTROL Inspection Level 21 X 26.00 Job Completion

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE		Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector			
		•								
						1				
NCR:		WORK ORDER NON-CONFO	DRMANCE (NC	R)						

NCR:		•	WORK ORDER NON-CONFORMANCE (NCR)							
	T	Description of NC	Corrective Action Section B			Verification	Approval			
DATE	STEP	Section A	Initial Design Mgr	Action Description  Design Mgr	Sign & Date	Section C	Design Mgr	Approval QC Inspector		
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						!		,		
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Part No:	PAR #:	Fault Category:	NCR:	Yes	No	DQA:	Date:
NOTE: Date & initial all entries				QA: N	I/C C	losed:	Date:

DART AEROSPACE LTD	Work Order:	28018
Description: Latch Bracket	Part Number:	D2583
Inspection Dwg: D2583 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Proto	уре

Drawing.	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension	Toterance	Dimension	Accept	L	Inspection	Johnnents
3.188	+/-0.010	3,188			Vern	
3.380	+/-0.010	3380	-		Vern	
0.907	+/-0.010	0.907			Vern	
1.725	+/-0.010	1.726			Vern	
R0.125	+/-0.010	RO.125			vern	
0.980	+/-0.010	0.980			Vern	
	1					
						- 1

Measured by: 5°AD	Audited by:	Prototype Approval:	N/A
Date: 06:08:14	Date: 06.08.20	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.06.25	New Issue	KJ/JLM	
				<del></del>



DESIG	E M.	DRAWN BY	DART AEROSPACE LT	D	
CHEC	KED	APPROVED LE	DRAWING NO. D2583 SHE	REV.	
DATE		<u></u>	TITLE	SCA	LE
99.0	2.22		LATCH BRACKET	2	:3
Α		96.07.10	NEW ISSUE		*****
Б		00 00 00	OLIANOS OS SINION (DED TOD A	~~~	

RELEASED В 99.02.22 CHANGE OF FINISH (PER TSR A887) 46.02.26 QSI 005 4.1 PER DART QSI 005 4.3 R0.125 (TYP 2 PLACES) OTHERWISE NOTED RO.125 (TYP) 0.600 (TYP) J RO.125 (TYP) F 0.373 1.725 MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK FINISH: ACID ETCH AND ALODINE PER DART QSI POWDER COAT WHITE (REF. 4.3.5.1) PER -RO.188 BEND RELIEF (TYP) PER DART 0.907 4.571 3.380 R0.125 (TYP) TOLERANCES ARE 0.980 SHOP COPY RETURN TO

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SUBJECT TO AMENDMEN

WORK ORDER NO. 28018